



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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C3-HC
Job Sheet 189538



Part No: C3-HC

Job Qty: 1 pcs

Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity With Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 12013 ship 28 february

Note: IPP Rev A 18.03.28 New issue DP Verify DD

order 13661

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	External Load - 1	1 pcs	2/28/19		0.00	0.00	External Load - 1		AP 2019/04/12
							External Load - 2		
							External Load - 3		
100	External Load - 2 - B4B	1 pcs	2/28/19		0.00	0.50	External Load - 1 - B4B		AP 2019/04/12
							External Load - 2 - B4B		
							External Load - 3 - B4B		
110	QC 5	1 pcs	2/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	DC - 1 - B4B	1 pcs	2/28/19		0.00	0.00	DC - 1 - B4B		68-6 30 DAS
							DC - 2 - B4B		
140	Packaging 3-1 - Stock - B4B	1 pcs	2/28/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

Date: 04/12/19



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Container No: S172178



Part: C3-HC

Job No: 189538

Serial No/Batch: S172178

Revision:

Inspector:

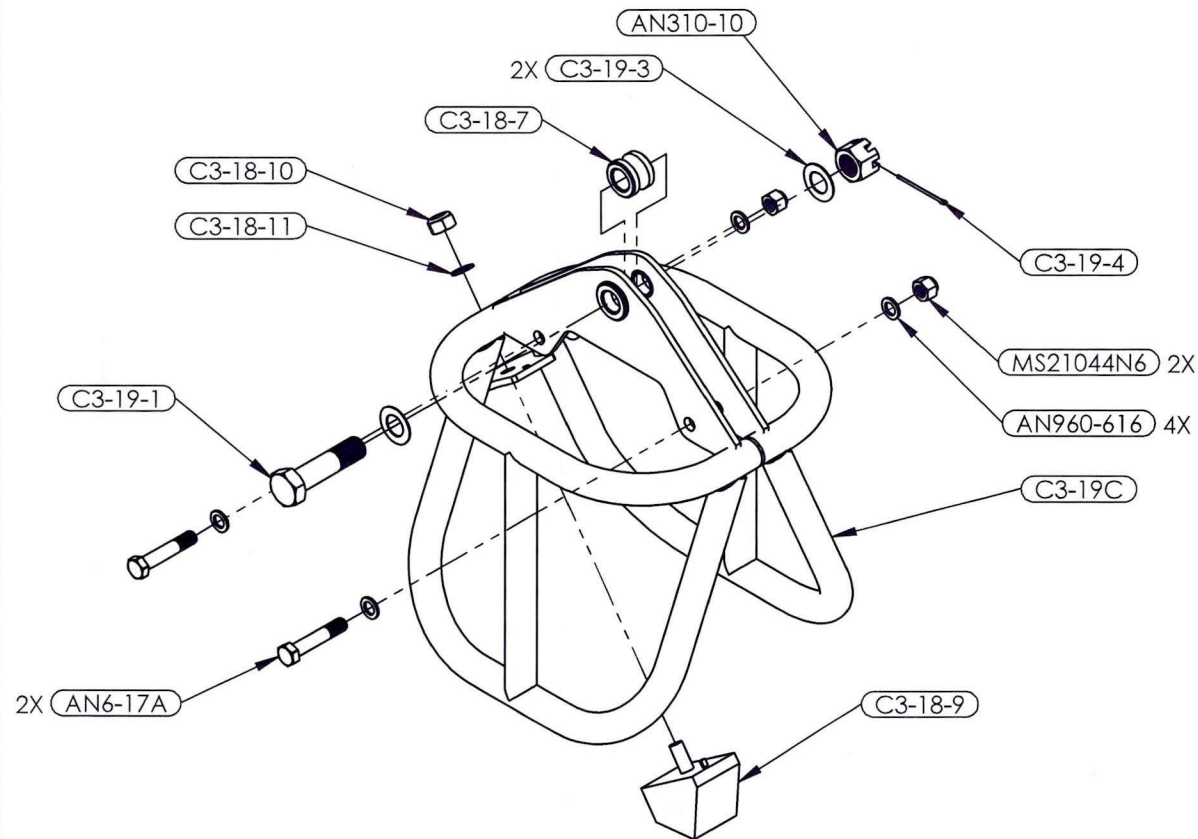
Exp Date:

Instructions:

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	889
				Packaging 3 - 9 - B4B	30
				Packaging 3 - 10 - B4B	DAS
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - FG	1 pcs	2/28/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
Part Op 95 - (Small Fab) Assemble the hook into the cage using the hardware called out on the C3-C drawing and torque Descriptions: fasteners AN6-17A to 160-190 in. lbs. and C-19-1 to 1100-1300 in. lbs. 100 - (Small Fab) Assemble the hook into the cage using the hardware called out on the C3-C drawing and torque fasteners AN6-17A to 160-190 in. lbs. and C-19-1 to 1100-1300 in. lbs. 110 - (QC5- Inspect part completeness to step on W/O) 120 - DC (Document Control) Photocopy blue file and create labels as per O&OPM-C3 140 - (Identify as per dwg & Stock Location: _____) 150 - QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
C3-C	Single Cage	1 Ea (1 ea)	95-External Load - 1	5170390	
C3	C-Series Remote Hook 3,000 lbs Lift Capacity	1 pcs (1 ea)	100-External Load - 2 - B4B	5158100	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
95-External Load - 1	C3-C	1	2	0	
100-External Load - 2 - B4B	C3	1	0	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		AS DRAWN BY CANAM	10/15/2012	JAG	
3A		C3-19-4 CH'D MAT'L WAS STEEL IS S.S., CH'D B/O INFO WAS #98338A200 IS #98401A480.	6/27/2014	DPD	JAG
4	15-0190	UPDATED TO NEW DRAFTING STANDARDS. CH'D TO MIL SPEC PART NUMBERS.	8/4/2015	DPD	JAG



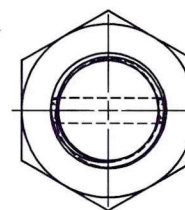
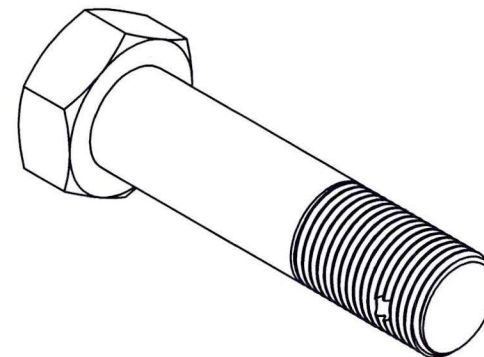
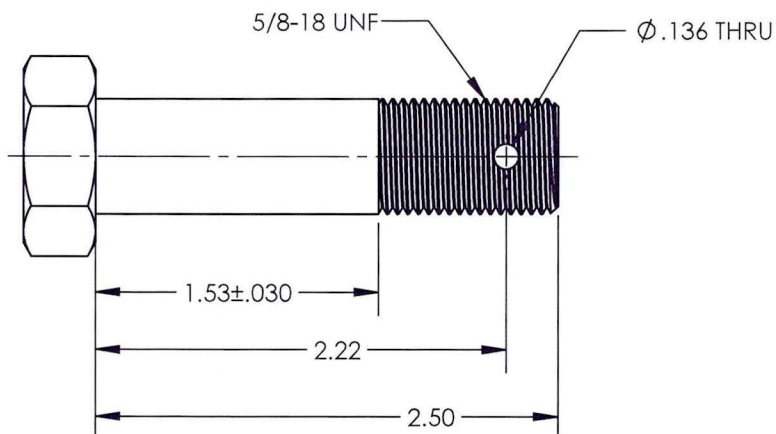
UNDER REVIEW
URF 19-656 19.03.27 (KPT)

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-19C	1	WELDMENT		
			C3-18-7	1	LIFTING BUSHING	4140 Q&T/4142 Q&T	
			C3-18-9	1	BUMPER	RUBBER	(#E37Z-4730-A)
		B/O	C3-18-10	1	CAGE BUMPER NUT	STEEL	M10x1.5, CLASS 8 (MCMASTER-CARR #90576A118)
		B/O	C3-18-11	1	CAGE BUMPER WASHER	STEEL	Ø3/8 (MCMASTER-CARR #91074A131)
			C3-19-1	1	LIFTING BOLT	STEEL	5/8-18 X 5 (MCMASTER-CARR #91257A833) MODIFIED
		B/O	C3-19-3	2	LIFTING BOLT WASHER	STEEL	Ø1.118 OD X Ø.640 ID X .032
		B/O	C3-19-4	1	COTTER PIN	S.S.	Ø1/8 X 2 MCMASTER-CARR #98401A480
		B/O	AN6-17A	2	CAGE BOLT	STEEL	3/8-24 X 1.953
		B/O	AN310-10	1	LIFTING BOLT NUT	STEEL	5/8-18 UNF-3B
		B/O	AN960-616	4	CAGE BOLT WASHER	STEEL	Ø3/8
		B/O	MS21044N6	2	CAGE BOLT NUT	STEEL	3/8-24

		TITLE	
		C3 CAGE	
DWG NO.		REV	
C3-C		4	
MAT'L		DRAWN BY: APICAL INDUSTRIES	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005		HEAT TREAT	
.XX ± .01		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	DATE	SHEET	
1:5	7/21/2009	1 OF 1	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	15-0252	UPDATED TO NEW DRAFTING STANDARDS. ADDED FINISH CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II.	8/27/2015	DPD	JAG
7	16-0228	CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2.	11/21/2016	DPD	JAG



UNDER REVIEW
URF 19-656 19.03.27 (KPT)

DART AEROSPACE	
TITLE LIFTING BOLT C3 CAGE	
DWG NO. C3-19-1	REV 7
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-19-1	1	LIFTING BOLT	STEEL	5/8-18 X 5, GRADE 8 (MCMASTER-CARR #91257A833) MODIFIED

SHEET 1 OF 1

Under Review Notification

Raised By: Ketan Tailor

Product #: C3-C

Date: March 27, 2019

Product Name: C3 CAGE

Part Number (D-Part and 9-Digit) (eg. D3535-11) (eg. D3535-25) (eg. D206-642-143) (eg. RBEM324U3010101-1)	Drawing or Document & <u>Current</u> Affected Revision for each part listed	"Y" or "N" Required for Each Part Do not leave blank							Reserved ECN / URF Log Number	Instructions Relevant to Each Part (including whether CHG #'s will be affected)
		DO NOT SHIP	Red Tag/Quarantine Stock	Advise Customers	Hold all Production	Re-Work Stock	IPP Under Review (Engineer Signoff Required.)	Put Product Specifications Under Review ("Bluefiles")		
C3-C	C3-C REV. 4	Y	Y	N	Y	Y	Y	N	19-656	See engineering
C3-19-1	C3-C REV. 4	Y	Y	N	Y	N	Y	N	19-656	Scrap
	</									

Description of Issue:

C3-19-1 must be scrapped and replaced with AN bolt. See engineering for work order deviation sign off

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

QC Coordinator

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

Supply Chain Director / Senior Buyer

Marketing Eugene